

Work Order ID 140668

January 13, 2016 11:21:55 AM

140668

Please cut Jan 14-18

Page 1

Complete order to ship Feb 1

Item ID: D4382-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Angled Bearpaw Clamp

Start Date: 1/13/2016 Start Qty: 20.00

20

Cust Item ID:

Required Date: 1/19/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

SLT

Date:

20160114

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4382	A								
100		0.00							
100									
Waterjet	Memo	0.02							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>B</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(24)

on 16/01/18

(24)

on 16/01/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Work Order ID 140668

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Page 2

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Start Date: 1/13/2016 Start Qty: 20.00

20

Cust Item ID:

Required Date: 1/19/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.01

Quality Control

DAS
38
9-89

JAN 18 2016

130

Form as per dwg

0.00

130

Brake NC

Memo

0.01

Brake NC

DAS
30
9-89

JAN 20 2016

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.01

Quality Control

DAS
38
9-89

JAN 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause				FAULT CATEGORY																																																																																																																											
Environment	☐	Design	☐	Doc/Data	☐	Equip/Tooling	☐	Handling/Pre	☐	Material	☐	Internal Transport	☐	Tribal Knowledge	☐	LOA	☐	Substation	☐	Past Expiry Date	☐	Misidentified	☐	No Re-verification	☐	Operator	☐	Offset/Setup	☐	Supplier	☐	Training	☐	Use for Testing	☐	Poor Information	☐	Rushing	☐	Product Improvement	☐	Process Improvement	☐	Manufacturing Process	☐	Past Due	☐	Pressure/Forced	☐	Bending	☐	Centre Not Concentric	☐	Cracks	☐	Crimp/Kink/Ripple/Wave	☐	Cuffs	☐	Crushing	☐	Heat Treat	☐	Wave/Twist in Tube	☐	Marks/Chatter	☐	Temperature/Cure	☐	Set-up	☐	BOM/Route	☐	Broken/Damage/Defect	☐	Inspection Incomplete/Unqualified	☐	Contamination	☐	Countersink	☐	Cut Too Short	☐	Instructions Incomplete/Unclear	☐	Drill Holes	☐	Power Loss/Surge	☐	Folio/Program	☐	Grain	☐	Weld	☐	Wrong Stock Pulled	☐	Out of Sequence	☐	Off-set	☐	Mislabeled	☐	Fit/Function	☐	Misaligned/off center	☐	Positioned Wrong	☐	Outside Dimensions	☐	Over/Under tolerance	☐	Part Incorrect	☐	Part Lost/Missing	☐	Part Moved	☐	Drawing	☐	Finish	☐	Misread	☐	Turning Sequence	☐
OTHER : _____																																																																																																																															

January 13, 2016 11:21:55 AM

Item ID: D4382-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Angled Bearpaw Clamp

Stop *NS2*

Start Date: 1/13/2016 **Start Qty:** 20.00

20

Cust Item ID:**Required Date:** 1/19/2016 **Req'd Qty:** 20.00

20

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

150

Identify as per dwg & Stock Location: 57544

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.03

Quality Control

21 DAS JAN 21 2016
6
8-89

ML5 JAN 21 2016

MCS JAN 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

January 13, 2016 11:22:00 AM

Page 1

Work Order ID: 140668

140668

Parent Item: D4382-1

D4382-1

Parent Item Name: Angled Bearpaw Clamp

Start Date: 1/13/2016

Required Date: 1/19/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 11.04.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No			100	sf	71.8000	0.05513	1.160632			

M304S14GA

304SS sheet .080

DA 16/01/18

Location

Loc Qty

Loc Code

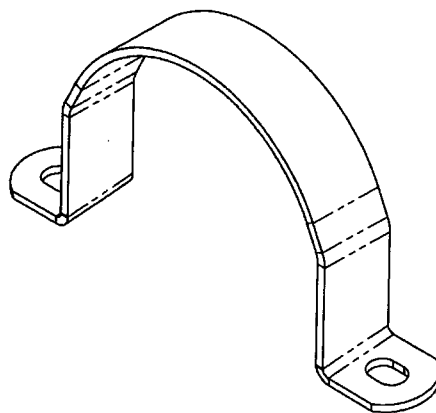
MAT019

71.8

M129972

71.8

1.5



D4382-1 ANGLED BEARPAW CLAMP

NOTES:

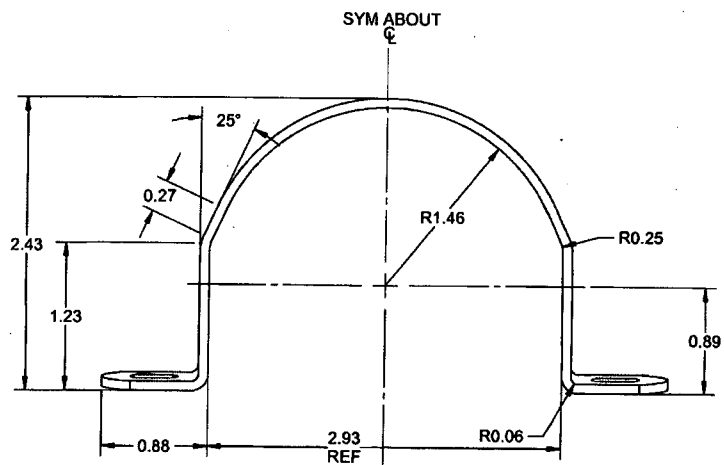
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4382-1" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 0.13 lbs

RELEASED
2011-04-21

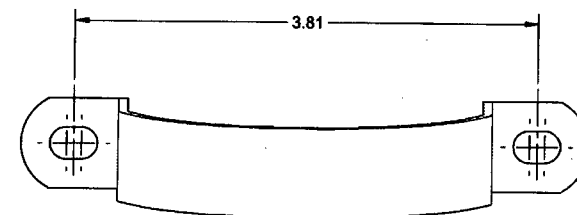
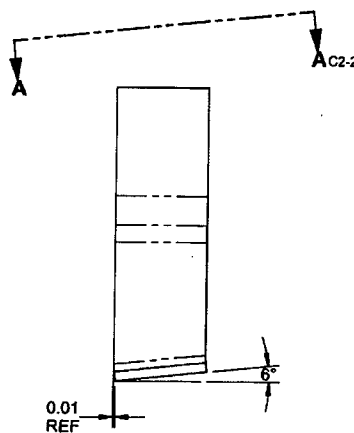
20160113

SH 140668

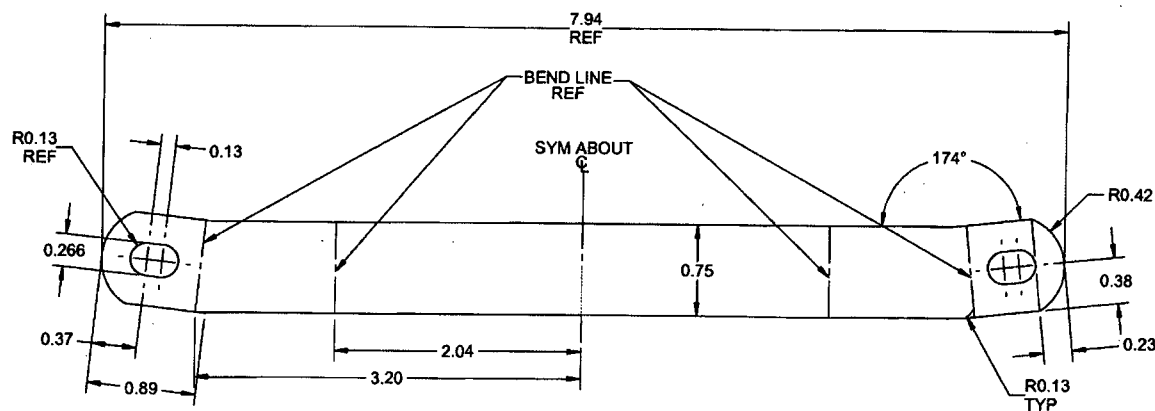
A	NEW ISSUE	AJS	11.03.28
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. A
CHECKED		D4382	SHEET 1 OF 2
MFG. APPR.		TITLE	SCALE
APPROVED		ANGLED BEARPAW CLAMP	NTS
DE APPR.		COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	11.03.28		



D4382-1 ANGLED BEARPAW CLAMP



VIEW A-A D3-2



**D4382-1F ANGLED BEARPAW CLAMP
(FLAT PATTERN)**

RELEASED
2011-04-21
MB

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D4382	REV. A
MFG. APPR.		SHEET 2 OF 2	
APPROVED		TITLE	SCALE
DE APPR.		ANGLED BEARPAW CLAMP	
DATE	11.03.28	NTS	
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